

Bimodal Epoxy Tank Lining

PRODUCT DESCRIPTION A two pack, low absorption, easy clean, high performance chemical tank coating.

INTENDED USES Suitable for the carriage of an extensive range of aggressive cargoes including solvents and chemicals, clean and dirty petroleum products, vegetable oils and animal oils.
For use at Newbuilding or Maintenance & Repair.

PRODUCT INFORMATION

Colour	TCA900-Buff, TCA901-Grey
Finish/Sheen	Gloss
Part B (Curing Agent)	TCA902
Volume Solids	80% ±2% (ISO 3233:1998)
Mix Ratio	7.52 volume(s) Part A to 1 volume(s) Part B
Typical Film Thickness	150 microns dry (188 microns wet)
Theoretical Coverage	5.33 m ² /litre at 150 microns dft, allow appropriate loss factors
Method of Application	Airless Spray, Brush, Roller
Flash Point (Typical)	Part A 34°C; Part B 100°C; Mixed 46°C
Induction Period	15 minutes

Drying Information	15°C	23°C	35°C
Touch Dry [ISO 9117/3:2010]	32 hrs	17 hrs	6 hrs
Hard Dry [ISO 9117-1:2009]	40 hrs	22 hrs	9 hrs
Pot Life		75 mins	60 mins

Overcoating Data - see limitations	Substrate Temperature					
	15°C		23°C		35°C	
Overcoated By	Min	Max	Min	Max	Min	Max
Interline 9001	48 hrs	5 days	28 hrs	4 days	16 hrs	3 days

REGULATORY DATA

VOC	177 g/lit as supplied (EPA Method 24) 93 g/kg of liquid paint as supplied. EU Solvent Emissions Directive (Council Directive 1999/13/EC) 115 g/lit Chinese National Standard GB23985
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Note: VOC values are typical and are provided for guidance purposes only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

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CERTIFICATION

When used as part of an approved scheme, this material has the following certification:

- Food Contact - FDA Compliant in accordance with section 175.300 of the Code of Federal Regulations

Consult your International Paint representative for details.

SYSTEMS AND COMPATIBILITY

Consult your International Paint representative for the system best suited for the surfaces to be protected.

SURFACE PREPARATIONS

Use in accordance with the standard Worldwide Marine Specifications.

All surfaces to be coated should be clean, dry and free from contamination.

High pressure fresh water wash or fresh water wash, as appropriate, and remove all oil or grease, soluble contaminants and other foreign matter in accordance with SSPC-SP1 solvent cleaning.

NEWBUILDING/MAJOR REFURBISHMENT

Where necessary, remove weld spatter and smooth weld seams and sharp edges.

Abrasive blast clean to Sa2½ (ISO 8501-1:2007). If oxidation has occurred between blasting and application of Interline 9001, the surface should be reblasted to the specified visual standard.

Surface defects revealed by the blast cleaning process, should be ground, filled, or treated in the appropriate manner.

REPAIR

Consult International Paint.

Consult your International Paint representative for specific recommendations.

NOTE

For use in Marine situations in North America, the following surface preparation standards can be used: SSPC-SP10 in place of Sa2½ (ISO 8501-1:2007)

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APPLICATION

Mixing	Material is supplied in 2 containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified. (1) Agitate Base (Part A) with a power agitator. (2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator. Mixed unit MUST BE >23°C during mixing and application.
Thinner	DO NOT THIN
Airless Spray	Recommended Tip Range 0.38-0.58 mm (15-23 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2500 p.s.i.)
Conventional Spray	Application by conventional spray is not recommended.
Brush	Application by brush is recommended for small areas only. Only flat headed brushes should be used. Multiple coats may be required to achieve specified film thickness.
Roller	Application by roller is recommended for small areas only. Multiple coats may be required to achieve specified film thickness.
Cleaner	International GTA415/GTA822
Work Stoppages and Cleanup	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA415/GTA822. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units. Clean all equipment immediately after use with International GTA415/GTA822. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays. Do not exceed pot life limitations. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.
Welding	In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation. In North America do so in accordance with instruction in ANSI/ASC Z49.1 "Safety in Welding and Cutting."

SAFETY

All work involving the application and use of this product should be performed in compliance with all relevant national Health, Safety & Environmental standards and regulations.

Prior to use, obtain, consult and follow the Material Safety Data Sheet for this product concerning health and safety information. Read and follow all precautionary notices on the Material Safety Data Sheet and container labels. If you do not fully understand these warnings and instructions or if you can not strictly comply with them, do not use this product. Proper ventilation and protective measures must be provided during application and drying to keep solvent vapour concentrations within safe limits and to protect against toxic or oxygen deficient hazards. Take precautions to avoid skin and eye contact (ie. gloves, goggles, face masks, barrier creams etc.) Actual safety measures are dependant on application methods and work environment.

EMERGENCY CONTACT NUMBERS:

USA/Canada - Medical Advisory Number 1-800-854-6813

Europe - Contact (44) 191 4696111. For advice to Doctors & Hospitals only contact (44) 207 6359191

China – Contact (86) 532 83889090

R.O.W. - Contact Regional Office

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LIMITATIONS

Film Thickness

The minimum dft for the system is 240 microns.
The maximum dft for the system is 450 microns.

In way of areas of tanks that are difficult to paint due to their configuration , e.g heavily stiffened tanks, and where a degree of overthickness is unavoidable, a maximum of 600 microns dft is acceptable.

This product will not cure adequately below 15°C. At no time during the application, and up to the first 48 hours after application of the final coat must the steel temperature fall below 15°C and the relative humidity exceed 50%. International Paint should be consulted to confirm that the tank coating is suitable for the range of cargoes to be carried. A mandatory heated post cure is required before the coating enters service - consult International Paint for further information.

The drying times and overcoating intervals may alter due to various on-site factors such as tank configuration and ventilation rates etc.

Overcoating information is given for guidance only and is subject to regional variation depending upon local climate and environmental conditions. Consult your local International Paint representative for specific recommendations. Temperature of the surface to be coated must be at least 3°C above the dew point and a minimum of 15°C. The minimum temperature of 15°C must be maintained throughout the application (including between coats) and for a minimum period of 48 hours after application of the final coat of the system. Base and Curing agent should be conditioned at 23°C for 48 hours prior to use. Mixed paint **MUST BE** >23°C during mixing and application.

UNIT SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	5 lt	4.41 lt	5 lt	0.59 lt	1 lt
	20 lt	17.65 lt	20 lt	2.35 lt	2.5 lt

Part B is supplied in lined pails.
For availability of other unit sizes consult International Paint

UNIT SHIPPING WEIGHT (TYPICAL)	Unit Size	Unit Weight
	5 lt	8.83 Kg
	20 lt	32.3 Kg

STORAGE	Shelf Life	Part A - 12 months at temperatures up to 25°C Part B - 12 months at temperatures up to 25°C Subject to reinspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition. If stored at temperatures below 10°C it is possible that crystallization of material will occur. This is not detrimental to product performance, but should be reincorporated prior to use by conditioning the paint at 23°C for 48 hours as per normal practice. Paint should be reinspected prior to use to ensure all crystallization is reincorporated. It is recommended to agitate paint prior to use to ensure homogeneous following reincorporation of crystallisation.

WORLDWIDE AVAILABILITY Consult International Paint.

IMPORTANT NOTE

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

This Technical Data Sheet is available on our website at www.international-marine.com or www.international-pc.com, and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.

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